

Date: Tuesday, 29/07/2008 4:58:51 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	407 UTILITY BASKET
Job Number :	40795		
Estimate Number :	10920		
P.O. Number :		Part Number :	D407663011
This Issue :	29/07/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2955 REV B
First Issue :	/ /	Project Number :	N/A
Previous Run :	36019	Drawing Revision :	B
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	29/08/2008
Written By :		Qty:	1 Um: Each
Checked & Approved By :	<u>JLD 08.7.29</u>		
Comment :	Est Rev:F 05.10.19 Added D2728-3 & AN960JD416L KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0

DC

DOCUMENT CONTROL



S 0261/20

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D407-663-011CHG002

003

per ECN 09-561

2.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Pick Assembly Kit

3.0

40795A

407 BASKET BASE ASSEMBLY

**Comment:** Sub-Component 407 BASKET BASE ASSEMBLY

1 x D2948-041

Batch

B40795A

E 08/09/29

4.0

40795B

407 BASKET LID

**Comment:** Sub-Component 407 BASKET LID

1 x D2952-041

Batch

B40795B

E 08/09/29

5.0

D2332041

Lid Prop Assembly 6.69" long



(X)

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 D2332-041

Prop Ass

B39332

8/8/5

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 29/07/2008 4:58:51 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 UTILITY BASKET

Job Number: 40795

Part Number: D407663011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2530 Handle Weldment ~~B40758~~ B40758

CP 08/09/29

sq

7.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2535 Spring B37021

sq

8.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2537 Bushing B39153

sq

9.0

D27283

Dart Logo Label - large



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2728-3 Label B22553

sq

10.0

D2851145

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 d2851-145 Placard B32019

sq

11.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2931 Bumper B21139

8/8/5

(1x)

sq

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Process Sheet

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Drawing Name: 407 UTILITY BASKET

Job Number: 40795

Part Number: D407663011

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2961

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 D2961

Label B12077

SP

13.0

AN320A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN3-20A

Bolt M15432

SP

14.0

AN414A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN4-14A

Bolt M107534

SP

15.0

AN422A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN4-22A

Bolt M107715

SP

16.0

AN517A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN5-17A

Bolt M108205

SP

17.0

AN521A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN5-21A

Bolt M16463

8/8/5

SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QA: N/C Closed: _____ Date: _____

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Drawing Name: 407 UTILITY BASKET

Job Number: 40795

Part Number: D407663011

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN960JD416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD416 Washer M108161

sq

19.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD416L Washer M108138

sq

20.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD516 Washer M108246

sq

21.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD8 Washer M107650

sq

22.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN970-4 Washer M108377

8/8/5

sq

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 UTILITY BASKET

Job Number: 40795

Part Number: D407663011

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS20600AD4W3 Rivet M18071

sq

24.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) M107665

sq

25.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L4 Nut (or -4) M107478

sq

26.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L5 Nut (or -5) M107939

8/8/5

sq

(1x)

27.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble basket as per Dwg D2955. Inspect for foreign objects as per QSI 024.

08/09/29 0

28.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/09/09 (x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 UTILITY BASKET

Job Number: 40795

Part Number: D407663011

Job Number:



Seq. #: Machine Or Operation: Description :

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

30.0

D2852

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Packing Kit

.Qty Part Number Description Batch
1 D2852 Label B33084

SP

31.0

D2984

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Packing Kit

.Qty Part Number Description Batch
1 D2984 Label B12605

SP

32.0

D407301011

Center Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Packing Kit

.Qty Part Number Description Batch
1 D407-301-011 Center Bracket Kit B40914

SP

33.0

D407302011

Outboard Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Packing Kit

.Qty Part Number Description Batch
1 D407-302-011 Outboard Bracket Kit B40915

SP

34.0

AN311A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Pick: Packing Kit

.Qty Part Number Description Batch
6 AN3-11A Bolt M14820

8/8/5

SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 UTILITY BASKET

Job Number: 40795

Part Number: D407663011

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

AN960JD10

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

.Qty Part Number Description Batch

6 AN960JD10 Washer M108558

SP

36.0

MS21042L3

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

.Qty Part Number Description Batch

6 MS21042L3 Nut (or -3) M107665

8/8/5

SP

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

506/20 (x)

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D407-663-011

Location:

PPP Rev: SD

9/1/00

SP

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/21

Job Completion



u 09/01/21

SLX D3863-1 B 44876
(D519428011
per GEN 09-501) W

~~02/05/94 28 07/1~~

B44877

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2955	REV. B SHEET 1 OF 2
DATE 00.07.17		TITLE BASKET ASSEMBLY	SCALE NTS
A	00.01.13	NEW ISSUE	
B	00.07.17	UPDATE TOP VIEW OF BASKET	

Qty -041	Part Number	Description
X	D2955-041	BASKET ASSEMBLY
1	D2332-041	LID PROP ASSEMBLY
1	D2530	HANDLE WELDMENT
2	D2535	SPRING
2	D2537	BUSHING
1	D2851-145	PLACARD
1	D2961	PLACARD
2	D2931	BUMPER
1	D2948-041	BASKET BASE ASSEMBLY
1	D2952-041	BASKET LID ASSEMBLY
2	AN3-20A	BOLT
2	AN4-14A	BOLT
2	AN4-22A	BOLT
2	AN5-17A	BOLT
2	AN5-21A	BOLT
6	AN960JD416	WASHER
4	AN960JD516	WASHER
2	AN960JD8	WASHER
4	AN970-4	WASHER
2	MS20600AD4W3	RIVET
2	MS21042L3	NUT (OR MS21042-3)
4	MS21042L4	NUT (OR MS21042-4)
4	MS21042L5	NUT (OR MS21042-5)

#00.09.08
RF#00.09.08
RF#00.09.08
RF

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40795

RELEASED
00.07.18 #

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D2952-041 BASKET
LID ASSEMBLY

AN4-22A BOLT (1)
AN960JD416 WASHER (1)
AN970-4 WASHER (2)
MS21042L4 NUT (1)

D2948-041 BASKET
BASE ASSEMBLY

PROP ARM DETAIL

SEE DETAIL B

D2332-041 LID
PROP ASSEMBLY

AN4-14A BOLT (1)
AN960JD416 WASHER (2)
MS21042L4 NUT (1)
(2 PLACES)

D2931 BUMPER (1)
MS20600AD4W3 (1)
AN960JD8 WASHER (1)
(2 PLACES)

RF 00.09.08
2

AN3-20A BOLT (1)
MS21042L3 NUT (1)
(2 PLACES)

DETAIL B
LATCH DETAIL

AN5-21A BOLT (1)
AN960JD516 WASHER (1)
MS21042L5 NUT (1)
(2 PLACES)

AN5-17A BOLT (1)
AN960JD516 WASHER (1)
MS21042L5 NUT (1)
(2 PLACES)

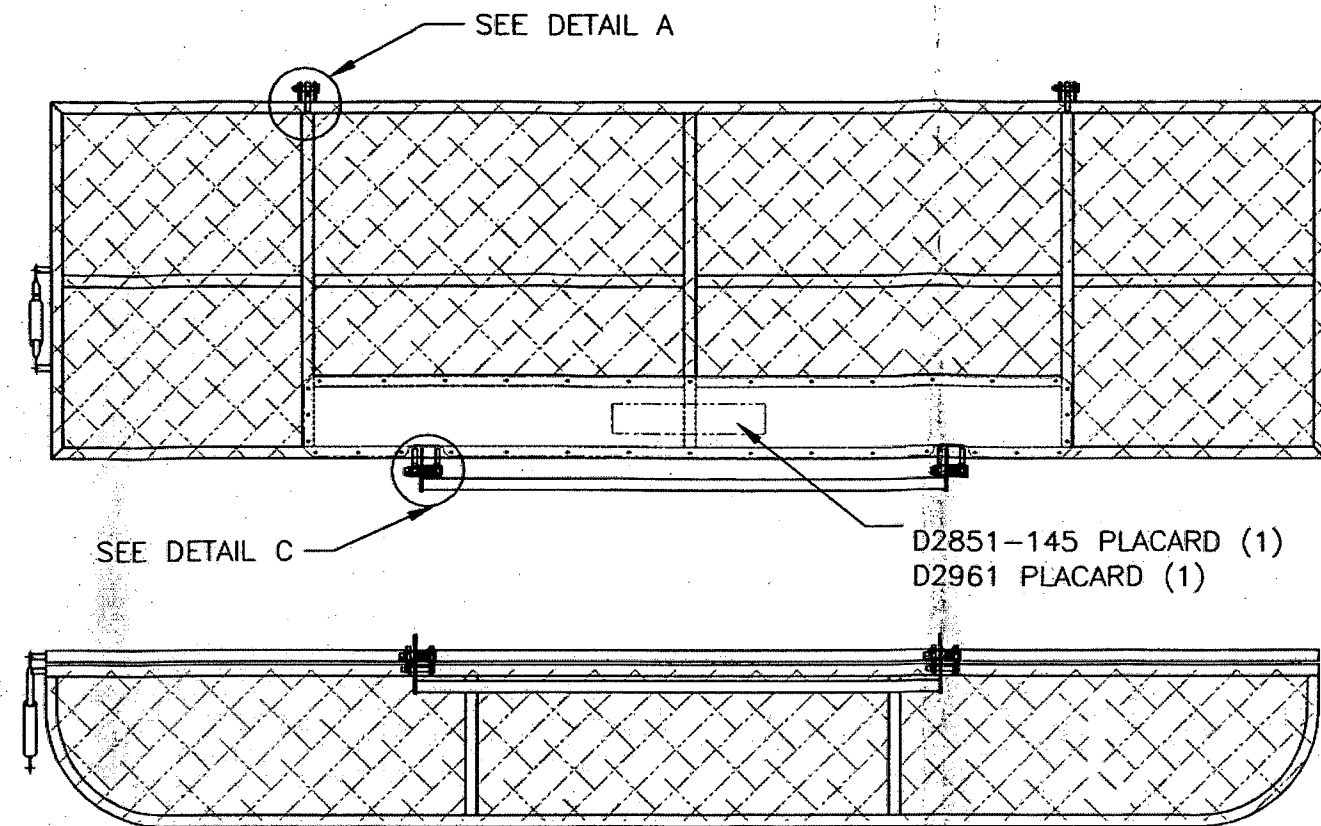
D2530 HANDLE (1)

D2535 SPRING (1)
D2537 BUSHING (1)
(2 PLACES)

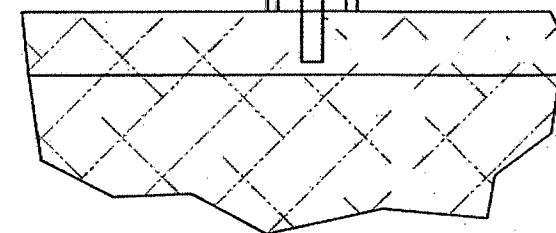
DETAIL C
SPRING DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40195

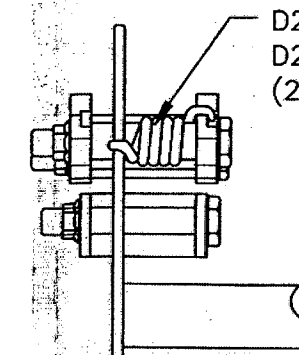
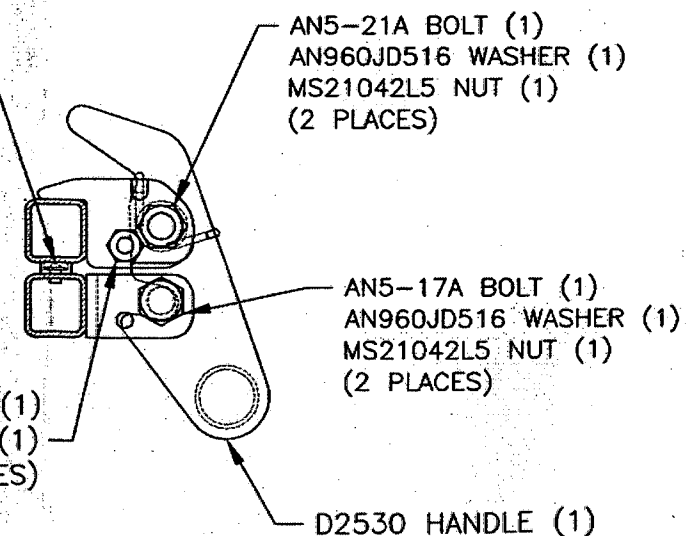
RELEASED
00.07.18



D2955-041 BASKET ASSEMBLY



DETAIL A
HINGE DETAIL



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DART AEROSPACE LTD.

DESIGN

RF

DRAWN BY

RF

CHECKED

RF

APPROVED

RF

DATE

00.07.17

DART

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D2955

REV. B

SHEET 2 OF 2

TITLE

BASKET ASSEMBLY

SCALE

NTS

ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD

Date: 09.01.08	Job No.: P00563	ADR Yes/No: Yes	ADR Date: 08.12.01	ECN #: 09- 501
Product No.: D407-663, D407-627		Created By: HS	Approved By: <i>[Signature]</i>	
Product Name: Heli-Utility Basket, Heli-Utility Pod		Checked By: <i>[Signature]</i>	General Manager Approval: <i>N/A</i>	

Distribution	Reqd	Resp	Initial / Date
Production Manager	Y	LL	
Production Engineering Coord	Y	EC	
Production Document Control	Y	JLB	
Customer Technical Support	Y	DS	

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord	Y	SS	
QC Coordinator	N		
Marketing	Y	SW	
Customer Order Processing	N		

Reason for Change:
The manual release cable connection could become hung up on the center D2796 support due to mis-alignment. See NCR 08-076

Documents Affected:
DSI 9428 Rev. A
D3863 Rev. A

PARTS MUST COMPLY ☒ PREVIOUS PARTS SATISFACTORY ☐

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	Y	SW	Helicopter Transport	
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	N			
5	Update Product Compatability Matrix	N			
6	Create Eurocopter Form (FEE)	N			
7	Notify TC / FAA of Change	N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
8	Move Electronic Files	Y	KJ		09.01.14 <i>[Signature]</i>
9	Update Blue/Pink/DSI Folder and Electronic Files	Y	KJ		09.01.14 <i>[Signature]</i>
10	Update Controlled PDF Files	Y	KJ		
11	Update Master Document List (MDL)	N			09.01.15 <i>[Signature]</i>
12	Update Document Record (DR)	Y	KJ	627 Rev L, 663 Rev D	
13	Update Product Development Summary	N			
14	Update QSI 021 and/or STC Approval List	N			09.01.14 <i>[Signature]</i>
15	Update Parts / STC Database	Y	KJ		09.01.14 <i>[Signature]</i>
16	Update / Verify ARC Database	Y	KJ	APPROVAL # 125 (627, 663 - DSI)	09.01.15 <i>[Signature]</i>
17	Create / Update Change Record Form	Y	KJ		09.01.15 <i>[Signature]</i>
18	Create / Update PPP's	Y	KJ		
19	Update Document Control Database / Laminated Dwgs	N			09.01.15 <i>[Signature]</i>
20	Update Grey Project Binder	Y	KJ	Add ADR	09.01.15 <i>[Signature]</i>
21	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		
22					
23					

Description / Action:

- DSI 9428 completes the corrective action for NCR 08-076.
- After reviewing the information and pictures that the customer provided it was decided to use a plastic sleeve around the manual release cable connection to prevent it from hanging up on the D3796 support (D3863-1). DSI 9428 was created to show customers how to install the D3863-1 sleeve.
- Update estimates to indicate D3863-1 as part of D407-627-013 and D407-663-011
- D407-627-013 now at CHG 005
- D407-663-011 now at CHG 003
- Add (1x) D3863-1 as well as a copy of DSI 9428 to all D407-627-013 and D407-663-011 kits in stock and change product labels.
- DSI 9428-011 NOW @ CHG 001

ECN Verified & Complete: _____

Date: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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